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(54) **Ejector with internal fluid path and moulding method**

Auswerfer mit internem Fluidkanal sowie Spritzgiessverfahren

Ejecteur avec conduit interne et procédé de moulage

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(73) Proprietor: **Hitachi Industrial Equipment Systems Co., Ltd.**
Chiba-shi,
Chiba (JP)

(72) Inventors:
• **Hirano, Toru,**
c/o Hitachi, Ltd.
Chiyodaku
Tokyo 100-8220 (JP)
• **Goto, Yasuhiro,**
c/o Hitachi, Ltd.
Chiyodaku
Tokyo 100-8220 (JP)

(74) Representative: **Iemenschot, Johannes Andreas**
Exter Polak & Charlouis B.V.,
P.O. Box 3241
2280 GE Rijswijk (NL)

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Description

Background of the Invention

[0001] The present invention relates to a mold and molding method for forming a product from a melted material.

[0002] In a prior art mold and molding method as disclosed by JP-A-9-267364, a stationary cooling pin in which a coolant is circulated and which is fixed to a movable side of the mold is surrounded by an ejector pin movable with respect to the movable side of the mold to remove a product or cured resin from the movable side of the mold.

[0003] In prior art document DE 100 05 300 C1 is shown a mold for producing plastic parts comprising an ejector which can be cooled.

[0004] In prior art document JP 9039043 is shown an ejector which can be cooled.

Brief Summary of the Invention

[0005] An object of the present invention is to provide a mold and molding method for forming a product from a melted material, in which the melted material is effectively cooled.

[0006] In a mold for forming a product from a melted material, comprising, first and second mold parts movable with respect to each other to contact each other in such a manner that a cavity is formed therebetween so that the melted material is capable of being inserted into the cavity and being subsequently solidified in the cavity to form the product, and to be separated from each other in such a manner that the product is capable of being taken out of the cavity, wherein one of the first and second mold parts has a material path for injecting the melted material into the cavity in such a manner that the melted material oriented along an injecting axis flows into the cavity, the other one of the first and second mold parts has a surface capable of defining a part of the cavity when the melted material is injected into the cavity, and an ejector pin including a front end surface capable of defining another part of the cavity when the melted material is injected into the cavity, wherein the ejector pin is movable with respect to the surface so that at least a part of the product is released (by the ejector pin from the other one of the first and second mold parts. When only a part of the product contacting the front end surface is released or removed by the ejector pin from the other one of the first and second mold parts, it is sometimes preferable or desired for the part of the product to be eliminated from a final product such as an optical recording disks.

According to the invention, since the movable ejector pin has a fluid path therein for enabling a fluid to pass through the ejector pin so that the front end surface is capable of being cooled by the fluid, the part of the product contact-

ing the front end surface to be moved by the movable ejector pin so that the at least a part of the product is released or removed by the ejector pin from the other one of the first and second mold parts, is effectively cooled through the whole of the front end surface, so that a start of the movement of the ejector pin for releasing or removing the at least a part of the product from the other one of the first and second mold parts is hastened even when a volume of the part of the product contacting the front end surface is great.

[0007] When the injecting axis crosses the front end surface, the part of the product contacting the front end surface is formed in a sprue lock so that the volume of the part of the product contacting the front end surface becomes necessarily great. Therefore, it becomes more important for hastening the start of the movement of the ejector pin that the movable ejector pin has the fluid path therein for enabling the fluid to pass through the ejector pin so that the front end surface is capable of being cooled by the fluid.

[0008] If the fluid is a gaseous matter, an adiabatic expansion of the fluid can be utilized for cooling the ejector pin.

[0009] If the ejector pin has a longitudinal outer peripheral surface expanding in a longitudinal direction of the ejector pin (that is, in a movable direction in which the ejector pin is movable with respect to the surface), and the fluid path opens to an outer environment of the ejector pin (that is, an outside of the ejector pin as seen in the movable direction) at a part of the longitudinal outer peripheral surface to enable the fluid to flow between an inside of the ejector pin and the outer environment of the ejector pin at the part of the longitudinal outer peripheral surface, preferably to discharge the fluid to flow from an inside of the ejector pin and to the outer environment of the ejector pin at the part of the longitudinal outer peripheral surface, the fluid is prevented from being heated by or in the ejector pin unnecessarily and the ejector pin is prevented from being heated by the fluid, so that the ejector pin is effectively cooled. If the fluid path has a portion distant from the part of the longitudinal outer peripheral surface in a flow of the fluid, and a distance between the front end surface and the portion in a movable direction in which the ejector pin is movable with respect to the surface is smaller than a distance between the front end surface and the part of the longitudinal outer peripheral surface in the movable direction, a slide area of the longitudinal outer peripheral surface of the ejector pin to be contacted with the other one of the first and second mold parts so that the ejector pin is movably supported by the other one of the first and second mold parts may be arranged in the vicinity of the front end surface while a distance between the fluid in the fluid path and the front end surface in the movable direction of the ejector pin is kept as small as possible. If the other one of the first and second mold parts has a space being arranged at the outside of the ejector pin and fluidly connected to the fluid path at the part of the longitudinal outer peripheral surface

to enable the fluid to flow in the space while contacting the longitudinal outer peripheral surface, preferably in a direction backing away from the front end surface, a length and area in which the fluid contacts the ejector pin can be great to increase the efficiency in cooling the ejector pin. If the space extends to surround the longitudinal outer peripheral surface of the ejector pin as seen in a movable direction in which the ejector pin is movable with respect to the surface, the length and area in which the fluid contacts the ejector pin can be further increased, and a distribution in temperature of the ejector pin in a radial and/or circumferential direction of the ejector pin is made constant.

[0010] It is preferable for effectively cooling the product contacting the front end surface that the fluid is capable of flowing through the fluid path while at least one of the melted material and the product contacts the front end surface. It is preferable for rapidly cooling the product contacting the front end surface just after the melted material reaches the front end surface that the fluid is capable of flowing through the fluid path after the product is removed from the front end surface, that is, before the melted material reaches the front end surface. The front end surface may expand in a direction perpendicular to a movable direction in which the ejector pin is movable with respect to the surface.

[0011] If the fluid is capable of flowing out from the ejector pin at the part of the longitudinal outer peripheral surface into the space, an adiabatic expansion of the fluid of gaseous matter is utilized to cool the ejector pin.

[0012] In a method for forming a product from a melted material, comprising the steps of moving first and second mold parts with respect to each other to contact each other so that a cavity is formed therebetween, injecting the melted material into the cavity, solidifying the melted material to form the product, moving the first and second mold parts with respect to each other to be separated from each other so that the product is capable of being taken out of the cavity, and moving an ejector pin including a front end surface defining a part of the cavity with respect to a surface of one of the first and second mold parts defining another part of the cavity in such a manner that at least a part of the product is released by the ejector pin from the one of the first and second mold parts. When only a part of the product contacting the front end surface is released or removed by the ejector pin from the one of the first and second mold parts, it is sometimes desired or preferable for the part of the product to be eliminated from a final product such as an optical recording disk.

According to the invention, since a fluid passes through the ejector pin so that the front end surface is cooled by the fluid during the step of solidifying the melted material, the part of the product contacting the front end surface to be moved by the movable ejector pin so that the at least a part of the product is released or removed by the ejector pin from the other one of the first and second mold

parts, is effectively cooled through the whole of the front end surface, so that a start of the movement of the ejector pin for releasing or removing the at least a part of the product from the other one of the first and second mold parts is hastened even when a volume of the part of the product contacting the front end surface is great.

[0013] If an injecting axis along which the melted material flowing into the cavity is oriented crosses the front end surface, the part of the product contacting the front end surface is formed in a sprue lock so that the volume of the part of the product contacting the front end surface becomes necessarily great. Therefore, it becomes more important for hastening the start of the movement of the ejector pin that the movable ejector pin has the fluid path therein for enabling the fluid to pass through the ejector pin so that the front end surface is capable of being cooled by the fluid.

[0014] If the fluid is a gaseous matter, the adiabatic expansion of the fluid can be utilized for cooling the ejector pin.

[0015] If the fluid flows between an inside of the ejector pin and an outside of the ejector pin (that is, an outer environment of the ejector pin as seen in a movable direction in which the ejector pin is movable) at a part of a longitudinal outer peripheral surface of the ejector pin expanding in a longitudinal direction of the ejector pin, preferably parallel to the movable direction, the fluid is prevented from being heated by or in the ejector pin unnecessarily and the ejector pin is prevented from being heated by the fluid, so that the ejector pin is effectively cooled. If the fluid flows to a portion distant from the part of the longitudinal outer peripheral surface in a flow of the fluid, and a distance between the front end surface and the portion in a movable direction in which the ejector pin is movable with respect to the surface is smaller than a distance between the front end surface and the part of the longitudinal outer peripheral surface in the movable direction, a slide area of the longitudinal outer peripheral surface of the ejector pin to be contacted with the other one of the first and second mold parts so that the ejector pin is movably supported by the other one of the first and second mold parts may be arranged in the vicinity of the front end surface while a distance between the fluid in the fluid path and the front end surface in the movable direction of the ejector pin is kept as small as possible. If the fluid flows in a space arranged at an outside of the ejector pin and fluidly connected to the fluid path at the part of the longitudinal outer peripheral surface while contacting the longitudinal outer peripheral surface, preferably in a direction backing away from the front end surface, a length and area in which the fluid contacts the ejector pin can be great to increase the efficiency in cooling the ejector pin. If the fluid flows in the space to surround the longitudinal outer peripheral surface of the ejector pin as seen in a movable direction in which the ejector pin is movable with respect to the surface, the length and area in which the fluid contacts the ejector pin can be further increased, and a distribution in tempera-

ture of the ejector pin in a radial and/or circumferential direction of the ejector pin is made constant.

[0016] It is preferable for effectively cooling the product contacting the front end surface that the fluid flows through the fluid path while at least one of the melted material and the product contacts the front end surface. It is preferable for rapidly cooling the product contacting the front end surface just after the melted material reaches the front end surface that the fluid flows through the fluid path after the product is removed from the front end surface, that is, before the melted material reaches the front end surface.

[0017] If the fluid flows out from the ejector pin at the part of the longitudinal outer peripheral surface into the space, the adiabatic expansion of the fluid of gaseous matter is utilized to cool the ejector pin.

[0018] Other objects, features and advantages of the invention will become apparent from the following description of the embodiments of the invention taken in conjunction with the accompanying drawings.

Brief Description of the Several Views of the Drawings

[0019]

Fig. 1 is a cross sectional view showing a mold of the invention.

Fig. 2 is an enlarged view showing an ejector pin for the mold of the invention.

Fig. 3 is a combination of front view, side view and horizontal view of the ejector pin.

Fig. 4 is a flow chart showing a process of forming a product from a melted material.

Detailed Description of the Invention

[0020] An embodiment of the invention is explained with using the drawings.

[0021] Fig. 1 shows a structure of a mold for an optical disk or the like, in which a cooling operation of the invention is utilized.

[0022] In fig. 1, a stationary side mold plate 1 is a main part forming a body of a stationary side mold, and a stationary mirror surface plate 3, a spool bush 14 and so forth are attached to the stationary side mold plate 1. Further, the stationary side mold plate 1 includes a coolant circuit 15 for controlling a temperature of the mold. A movable side mold plate 2 is a main part forming a body of a movable side mold, and a movable side mirror surface plate 4, an ejector mechanism and so forth are attached to the movable side mold plate 2. The movable side mold plate 2 includes the coolant circuit 15 for controlling the temperature of the mold.

[0023] During molding, a melted resin is injected into a molding portion 22 and cooled to be solidified to form a disk-shape, the stationary mirror surface plate 3 forms a main surface of the disk, and the movable side mirror surface plate 4 forms a reverse surface thereof. Further,

an outer peripheral ring 5 forms an outer peripheral side surface of the disk, and these three members form a disk forming portion 22. The mirror surface plates includes the coolant circuit for keeping a mold temperature at an appropriate degree.

[0024] An ejector sleeve 6 is a tubular member for taking the disk formed and solidified in the disk forming portion 22 out of the disk forming portion 22 with a protruding of the ejector sleeve 6. A combination of the forward protruding and a backward withdrawal for next molding is repeated at every molding of one disk.

[0025] A cut punch 7 is a member for forming a center hole ($\phi 15\text{mm}$) of the disk. This member is arranged within the ejector sleeve. When the melted resin is cooled to be solidified in the molding portion 22, the cut punch moves forward to form the hole. A cylinder 8 includes an ejector mechanism such as an ejector sleeve 6, the cut punch 7 and so forth.

[0026] An ejector pin 9 includes an axial air hole 16 into which a cooling air is introduced, and a hole extending radially outward to discharge the cooling air in the vicinity of an end of the pin. The ejector pin 9 moves forward to remove the resin filling a sprue lock 21 from the cut punch 7.

[0027] A first ejector plate 10 and a second ejector plate 11 hold the ejector pin 9 to push out the resin cured in the sprue lock 21 of the cut punch 7. A flange of the ejector pin 9 is clamped by the first and second ejector plates 10 and 11. The second ejector plate 11 has an air hole 17 for introducing the air from an air supply into the air hole 16 of the ejector pin 9, and an O-ring in a groove to prevent a leakage of the air.

[0028] A pressing plate 12 is a member for pressing ejector mechanism members such as the cut punch 7, the ejector sleeve 6 and so forth incorporated in the movable side mold plate 4. A locating ring 13 is a member for positioning between the mold and an injection machine so that a nozzle of the injection machine for injecting the melted resin is aligned with a sprue 23 of the mold. A sprue bush 14 is a member for guiding the melted resin injected by the nozzle of the injection machine to the molding portion 22 of the mold. A coolant hole 15 is formed in the mold to circulate a cooling medium so that the temperature of the mold is kept at an appropriate temperature suitable for molding of the resin.

[0029] The air hole 16 is arranged in the ejector pin 9 to enable the cooling air therethrough. This hole extends axially in the ejector pin 9 and the hole for discharging the air radially outwardly is arranged in the vicinity of the end of the ejector pin. The air hole 17 is a hole for introducing the air from the air supply on the second ejector plate 11 into the air hole 16 in the ejector pin 9. The O-ring 18 prevents the air from leaking at a joint between members when the cooling air is introduced into the air hole 16 in the ejector pin 9 through the air hole in the second ejector plate 11 from the air supply. A joint 19 and an air tube 20 are used to pass the air from the air supply through the air hole 17 in the second ejector plate

11. The air tube 2 and the air hole 17 of the second ejector plate 11 are connected by a joint attached to the second ejector plate 11. 21 denotes the sprue lock, 23 denotes the sprue, and 24 denotes an air discharge space.

[0030] Fig. 2 is an enlarged partial view of the ejector pin of the invention as shown in fig. 1. The ejector pin 9 has the air hole 16 terminating axially and the hole extending radially outward from the air hole 16 to discharge the air at the vicinity of the terminating end of the air hole 16. The air discharged from the ejector pin 9 flows in the discharge space 24 surrounding the ejector pin 9 to be discharged to the outer atmosphere. A front end of the ejector pin 9 in the vicinity of the terminating end of the air hole 16 contacts the sprue lock 21 to be effectively cooled. A relief path 24 surrounds a part of the longitudinal outer peripheral surface of the ejector pin 9 (other than another part thereof to be supported by the plate 2 or 4 in the vicinity of the front end of the ejector pin 9) and extends to the outside of the mold to discharge the air from the inside of the ejector pin 9 to the outside of the mold.

[0031] Fig. 3 shows the holes for discharging the air through an outer periphery of the ejector pin 9 from the air hole 16 thereof.

[0032] In fig. 3, an outer diameter of the ejector pin of the mold for molding the disk is about $\phi 2-5$ mm, and a diameter of the air hole 16 is about $\phi 1-3$ mm.

[0033] The holes 27 for discharging the air through the outer periphery of the ejector pin is 2 while being arranged symmetrically in fig. 3, and the orientations of the holes 27 form acute angle with respect to the air hole 16 to decrease a resistance for circulation of the air to be discharged.

[0034] A member of the hole 27 is 2 in fig. 3, but may be 4 and so forth.

[0035] Fig. 4 shows a process for producing an optical disk of polycarbonate resin with $\phi 120$ mm.

[0036] In a step of clamping the mold, the movable side mold see (lower side in fig. 1) is moved forward to contact the stationary side mold to be clamped each other. The ejector pin 9 pushing out the sprue lock 21 has the axial air hole 16 for passing the air at a radial center so that the cooling air flows to cool the front end of the ejector pin during the molding.

[0037] In a step of injecting the melted resin after the clamping the mold, a melted polycarbonate resin is injected into the mold from the nozzle of the injection machine through the sprue bush 14, so that the molding portion 22 formed by the stationary side mirror surface plate 3 and the movable side mirror surface plate 4 is filled with the melted polycarbonate resin.

[0038] After the molding portion 22 is filled with the melted resin, the resin in the molding portion 22 is cooled by the cooling water flowing through the cooling hole 15 of the mold so that the melted resin is solidified. During the solidifying, the central hole ($\phi 15$ mm) of the disk is formed. In this step, a time period for solidifying the resin in the sprue lock 21 is longer than a time period for so-

lidifying a ring portion of the disk, so that a cycle time period of the molding is determined by the time period for solidifying the resin in the sprue lock 21. Therefore, the cooling air passes through the hole 16 in the ejector pin 9 to cool the front end of the ejector pin 9 so that the resin in the sprue lock 21 is cooled, whereby the time period for the solidifying is decreased to decreased the cycle time period of the molding.

[0039] In a step of opening the mold by moving backward the movable side mold, a product of disk 26 is held by the movable side mold on which the sprue lock 21 is arranged.

[0040] Subsequently, the resin in the sprue lock 21 is pushed out therefrom by the ejector pin 9, and the product of disk 26 is pushed out by the ejector sleeve 6 from the movable side mold.

[0041] Thereafter, the ejector pin and the ejector sleeve return respective initial positions to perform the step of clamping the mold, and the molding is repeated.

[0042] By cooling the resin in the sprue lock by the front surface of the ejector pin, the cycle time period of the molding is decreased to improve a production efficiency.

[0043] It should be further understood by those skilled in the art that although the foregoing description has been made on embodiments of the invention, the invention is not limited thereto and various changes and modifications may be made without departing from the scope of the appended claims.

Claims

1. A mold for forming a product (26) from a melted material, comprising, stationary side and movable side mold parts (1, 3; 2, 4, 6, 7) movable with respect to each other to contact each other in such a manner that a cavity (22) is formed therebetween so that the melted material is capable of being inserted into the cavity and being subsequently solidified in the cavity to form the product, and to be separated from each other in such a manner that the product is capable of being taken out of the cavity, wherein the stationary side mold part (1, 3) has a material path (23) for injecting the melted material oriented along an injecting axis flows into the cavity (22), the movable side mold part (2, 4, 6, 7) has a surface capable of defining a part of the cavity (22) when the melted material is injected into the cavity (22), an ejector pin (9) including a front end surface capable of defining another part of the cavity (22) when the melted material is injected into the cavity (22), wherein the ejector pin (9) is movable with respect to the surface so that at least a part of the product is released from the movable side mold part (2, 4, 6, 7), the ejector pin (9) has a fluid path (16) for enabling a fluid to pass through the ejector pin (9) so that the front end surface is capable of being cooled by the fluid, and

the movable side mold part (2, 4, 6, 7) has a first cylindrical surface surrounding a part of the ejector pin (9) to form a relief path (24) for discharging the fluid from the inside of the ejector pin (9) to the outside of the mold and a second cylindrical surface supporting another part of the ejector pin (9) in the vicinity of the front end surface, wherein, an outlet port of the fluid path (16) is arranged on an outer periphery of the ejector pin (9) so that the fluid path (16) opens to the relief path (24) when the stationary side and movable mold parts (1, 3; 2, 4, 6, 7) contact each other to form the cavity before the ejector pin (9) moves with respect to the surface to release the at least a part of the product from the movable side mold part (2, 4, 6, 7),

characterized in that the fluid path (16) terminates in the vicinity of the front end surface to extend into the second cylindrical surface when the stationary side and movable side mold parts (1, 3; 2, 4, 6, 7) contact each other to form the cavity (22) before the ejector pin (9) moves with respect to the surface to release the at least a part of the product from the movable side mold part (2, 4, 6, 7), and **in that** the outlet port of the fluid path is arranged so that the fluid path (16) is closed by the second cylindrical surface when the ejector pin (9) moves with respect to the surface to release the at least a part of the product from the movable side mold part (2, 4, 6, 7).

2. A mold according to claim 1, **characterized in that** the front end surface in the vicinity of the terminating end of the fluid path (16) faces to a sprue lock (21) of the movable side mold part (2, 4, 6, 7) so that the melted material in the sprue lock (21) to be solidified is effectively cooled by the fluid through the front end surface.
3. A method for forming a product from a melted material, comprising the steps of moving stationary side and movable side mold parts (1, 3; 2, 4, 6, 7) with respect to each other to contact each other so that a cavity (22) is formed therebetween, injecting the melted material into the cavity (22), solidifying the melted material to form the product, moving the stationary side and movable side mold parts (1, 3; 2, 4, 6, 7) with respect to each other to be separated from each other so that the product is capable of being taken out of the cavity (22), and moving an ejector pin (9) including a front end surface defining a part of the cavity (22) with respect to a surface of the movable side mold part (2, 4, 6, 7) defining another part of the cavity (22) in such a manner that at least a part of the product is released from the movable side mold part (2, 4, 6, 7), wherein a fluid passes through the ejector pin (9) so that the front end surface is cooled by the fluid during the step of solidifying the melted material, and the movable side mold part (2, 4, 6, 7) has a first cylindrical surface surrounding

a part of the ejector pin (9) to form a relief path (24) for discharging the fluid from the inside of the ejector pin (9) to the outside of the mold and a second cylindrical surface supporting another part of the ejector pin (9) in the vicinity of the front end surface, **characterized in that** during the step of solidifying the melted material, the ejector pin (9) is positioned in such a manner that the fluid path (16) terminating in the vicinity of the front end surface extends into the second cylindrical surface, and **in that** the ejector pin (9) is positioned during the steps of injecting the melted material into the cavity (22) and solidifying the melted material in such a manner that an outlet port of the fluid path on the outer periphery of the ejector pin (9) opens to the relief path (24), and the ejector pin (9) is positioned during the step of moving the ejector pin (9) in such a manner that the fluid path (16) is closed by the second cylindrical surface.

Patentansprüche

1. Form zum Formen eines Produkts (26) aus einem Schmelzmaterial, die aufweist: ein stationäres und ein bewegliches Formteil (1, 3; 2, 4, 6, 7), die relativ zueinander beweglich sind, um einander so zu kontaktieren, daß ein Hohlraum (22) dazwischen gebildet ist, so daß das Schmelzmaterial in den Hohlraum eingeleitet und anschließend im Hohlraum verfestigt werden kann, um das Produkt zu formen, und voneinander so getrennt zu werden, daß das Produkt aus dem Hohlraum entnommen werden kann, wobei das stationäre Formteil (1, 3) einen Materialweg (23) zum Einspritzen des Schmelzmaterials hat, der entlang einer Einspritzachse in den Hohlraum (22) orientiert ist, das bewegliche Formteil (2, 4, 6, 7) eine Oberfläche hat, die einen Teil des Hohlraums (22) bilden kann, wenn das Schmelzmaterial in den Hohlraum (22) eingespritzt wird, und einen Auswerferstift (9) mit einer vorderen Endfläche, die einen weiteren Teil des Hohlraums (22) bilden kann, wenn das Schmelzmaterial in den Hohlraum (22) eingespritzt wird, wobei der Auswerferstift (9) relativ zur Oberfläche beweglich ist, so daß mindestens ein Teil des Produkts aus dem beweglichen Formteil (2, 4, 6, 7) gelöst wird, und der Auswerferstift (9) einen Fluidweg (16) zum Durchgang eines Fluids durch den Auswerferstift (9) hat, so daß die vordere Endfläche durch das Fluid abgekühlt werden kann, und das bewegliche Formteil (2, 4, 6, 7) eine erste Zylinderfläche, die einen Teil des Auswerferstifts (9) umgibt, um einen Entlastungsweg (24) zum Abgeben des Fluids aus dem Inneren des Auswerferstifts (9) zum Äußeren der Form zu bilden, und eine zweite Zylinderfläche hat, die einen weiteren Teil des Auswerferstifts (9) in der Umgebung der vorderen Endfläche abstützt, wobei eine Auslaßöffnung des Fluidwegs (16) auf einem Außenumfang des Auswerferstifts (9)

angeordnet ist, so daß der Fluidweg (16) zum Entlastungsweg (24) öffnet, wenn das stationäre und das bewegliche Formteil (1, 3; 2, 4, 6, 7) einander kontaktieren, um den Hohlraum zu bilden, bevor sich der Auswerferstift (9) relativ zur Oberfläche bewegt, um den mindestens einen Teil des Produkts aus dem beweglichen Formteil (2, 4, 6, 7) zu lösen,

dadurch gekennzeichnet, daß der Fluidweg (16) in der Umgebung der vorderen Endfläche so endet, daß er sich in die zweite Zylinderfläche erstreckt, wenn das stationäre und das bewegliche Formteil (1, 3; 2, 4, 6, 7) einander kontaktieren, um den Hohlraum (22) zu bilden, bevor sich der Auswerferstift (9) relativ zur Oberfläche bewegt, um den mindestens einen Teil des Produkts aus dem beweglichen Formteil (2, 4, 6, 7) zu lösen, und daß die Auslaßöffnung des Fluidwegs so angeordnet ist, daß der Fluidweg (16) durch die zweite Zylinderfläche geschlossen wird, wenn sich der Auswerferstift (9) relativ zur Oberfläche bewegt, um den mindestens einen Teil des Produkts aus dem beweglichseitigen Formteil (2, 4, 6, 7) zu lösen.

2. Form nach Anspruch 1, **dadurch gekennzeichnet, daß** die vordere Endfläche in der Umgebung des Abschlußendes des Fluidwegs (16) zu einem Angußabreißer (21) des beweglichen Formteils (2, 4, 6, 7) weist, so daß das zu verfestigende Schmelzmaterial im Angußabreißer (21) durch das Fluid durch die vordere Endfläche wirksam abgekühlt wird.
3. Verfahren zum Formen eines Produkts aus einem Schmelzmaterial mit den Schritten: Bewegen eines stationären und eines beweglichen Formteils (1, 3; 2, 4, 6, 7) relativ zueinander, um einander zu kontaktieren, so daß ein Hohlraum (22) dazwischen gebildet ist, Einspritzen des Schmelzmaterials in den Hohlraum (22), Verfestigen des Schmelzmaterials, um das Produkt zu formen, Bewegen des stationären und des beweglichen Formteils (1, 3; 2, 4, 6, 7) relativ zueinander, um voneinander getrennt zu werden, so daß das Produkt aus dem Hohlraum (22) entnommen werden kann, und Bewegen eines Auswerferstifts (9) mit einer vorderen Endfläche, die einen Teil des Hohlraums (22) bildet, relativ zur Oberfläche des beweglichen Formteils (2, 4, 6, 7), die einen weiteren Teil des Hohlraums (22) bildet, so daß mindestens ein Teil des Produkts aus dem beweglichen Formteil (2, 4, 6, 7) gelöst wird, wobei ein Fluid den Auswerferstift (9) durchläuft, so daß die vordere Endfläche im Schritt des Verfestigens des Schmelzmaterials durch das Fluid abgekühlt wird, und das bewegliche Formteil (2, 4, 6, 7) eine erste Zylinderfläche, die einen Teil des Auswerferstifts (9) umgibt, um einen Entlastungsweg (24) zum Abgeben des Fluids aus dem Inneren des Auswerferstifts (9) zum Äußeren der Form zu bilden, und eine zweite

Zylinderfläche hat, die einen weiteren Teil des Auswerferstifts (9) in der Umgebung der vorderen Endfläche abstützt,

dadurch gekennzeichnet, daß im Schritt des Verfestigens des Schmelzmaterials der Auswerferstift (9) so positioniert wird, daß sich der in der Umgebung der vorderen Endfläche endende Fluidweg (16) in die zweite Zylinderfläche erstreckt, und daß der Auswerferstift (9) in den Schritten des Einspritzens des Schmelzmaterials in den Hohlraum (22) und Verfestigens des Schmelzmaterials so positioniert wird, daß eine Auslaßöffnung des Fluidwegs auf dem Außenumfang des Auswerferstifts (9) zum Entlastungsweg (24) öffnet, und der Auswerferstift (9) im Schritt des Bewegens des Auswerferstifts (9) so positioniert wird, daß der Fluidweg (16) durch die zweite Zylinderfläche geschlossen wird.

20 Revendications

1. Moule destiné à former un produit (26) à partir d'un matériau fondu, comportant des parties de moule côté fixe et côté mobile (1, 3 ; 2, 4, 6, 7) mobiles l'une par rapport à l'autre pour entrer en contact l'une avec l'autre de manière à ce qu'une cavité (22) soit formée entre celles-ci de telle sorte que le matériau fondu peut être introduit dans la cavité et être ensuite solidifié dans la cavité pour former le produit, et pouvant être séparées l'une de l'autre de manière à pouvoir extraire le produit de la cavité, dans lequel la partie de moule côté fixe (1, 3) a un trajet de matériau (23) pour injecter le matériau fondu orienté le long d'un axe d'injection qui s'écoule dans la cavité (22), la partie de moule côté mobile (2, 4, 6, 7) a une surface pouvant définir une partie de la cavité (22) lorsque le matériau fondu est injecté dans la cavité (22), une broche d'éjecteur (9) incluant une surface d'extrémité avant pouvant définir une autre partie de la cavité (22) lorsque le matériau fondu est injecté dans la cavité (22), dans lequel la broche d'éjecteur (9) est mobile par rapport à la surface de telle sorte qu'au moins une partie du produit est libérée de la partie de moule côté mobile (2, 4, 6, 7), la broche d'éjecteur (9) a un trajet de fluide (16) pour permettre à un fluide de passer à travers la broche d'éjecteur (9) de telle sorte que la surface d'extrémité avant peut être refroidie par le fluide, et la partie de moule côté mobile (2, 4, 6, 7) a une première surface cylindrique entourant une partie de la broche d'éjecteur (9) pour former un trajet de décharge (24) pour évacuer le fluide à partir de l'intérieur de la broche d'éjecteur (9) vers l'extérieur du moule et une seconde surface cylindrique supportant une autre partie de la broche d'éjecteur (9) au voisinage de la surface d'extrémité avant, dans lequel un orifice de sortie du trajet de fluide (16) est agencé sur une périphérie extérieure de la broche d'éjecteur (9) de telle sorte que le trajet

de fluide (16) débouche dans le trajet de décharge (24) lorsque les parties de moule côté fixe et côté mobile (1, 3 ; 2, 4, 6, 7) sont en contact l'une avec l'autre pour former la cavité avant que la broche d'éjecteur (9) ne se déplace par rapport à la surface pour libérer la au moins une partie du produit de la partie de moule côté mobile (2, 4, 6, 7),

caractérisé en ce que le trajet de fluide (16) se termine au voisinage de la surface d'extrémité avant pour s'étendre dans la seconde surface cylindrique lorsque les parties de moule côté fixe et côté mobile (1, 3 ; 2, 4, 6, 7) sont en contact l'une avec l'autre pour former la cavité (22) avant que la broche d'éjecteur (9) ne se déplace par rapport à la surface pour libérer la au moins une partie du produit de la partie de moule côté mobile (2, 4, 6, 7), et **en ce que** l'orifice de sortie du trajet de fluide est disposé de telle sorte que le trajet de fluide (16) est fermé par la seconde surface cylindrique lorsque la broche d'éjecteur (9) se déplace par rapport à la surface pour libérer la au moins une partie du produit de la partie de moule côté mobile (2, 4, 6, 7).

2. Moule selon la revendication 1, **caractérisé en ce que** la surface d'extrémité avant au voisinage de l'extrémité terminale du trajet de fluide (16) est dirigée vers un arrache-carotte (21) de la partie de moule côté mobile (2, 4, 6, 7) de telle sorte que le matériau fondu dans l'arrache-carotte (21) à solidifier est efficacement refroidi par le fluide par l'intermédiaire de la surface d'extrémité avant.

3. Procédé pour former un produit à partir d'un matériau fondu, comportant les étapes consistant à déplacer des parties de moule côté fixe et côté mobile (1, 3 ; 2, 4, 6, 7) l'une par rapport à l'autre pour entrer en contact l'une avec l'autre de telle sorte qu'une cavité (22) est formée entre celles-ci, injecter le matériau fondu dans la cavité (22), solidifier le matériau fondu pour former le produit, déplacer les parties de moule côté fixe et côté mobile (1, 3 ; 2, 4, 6, 7) l'une par rapport à l'autre pour les séparer l'une de l'autre de telle sorte que le produit peut être extrait de la cavité (22), et déplacer une broche d'éjecteur (9) incluant une surface d'extrémité avant définissant une partie de la cavité (22) par rapport à une surface de la partie de moule côté mobile (2, 4, 6, 7) définissant une autre partie de cavité (22) de manière à ce qu'au moins une partie du produit soit libérée de la partie de moule côté mobile (2, 4, 6, 7), dans lequel un fluide passe à travers la broche d'éjecteur (9) de telle sorte que la surface d'extrémité avant est refroidie par le fluide pendant l'étape de solidification du matériau fondu, et la partie de moule côté mobile (2, 4, 6, 7) a une première surface cylindrique entourant une partie de la broche d'éjecteur (9) pour former un trajet de décharge (24) pour évacuer le fluide à partir de l'intérieur de la broche d'éjecteur (9) vers l'exté-

rieur du moule et une seconde surface cylindrique supportant une autre partie de la broche d'éjecteur (9) au voisinage de la surface d'extrémité avant, **caractérisé en ce que** pendant l'étape de solidification du matériau fondu, la broche d'éjecteur (9) est positionnée de manière à ce que le trajet de fluide (16) se terminant au voisinage de la surface d'extrémité avant s'étende dans la seconde surface cylindrique, et **en ce que** la broche d'éjecteur (9) est positionnée, pendant les étapes d'injection du matériau fondu dans la cavité (22) et de solidification du matériau fondu, de manière à ce qu'un orifice de sortie du trajet de fluide sur la périphérie extérieure de la broche d'éjecteur (9) débouche dans le trajet de décharge (24), et la broche d'éjecteur (9) est positionnée pendant l'étape de déplacement de la broche d'éjecteur (9) de manière à ce que le trajet de fluide (16) soit fermé par la seconde surface cylindrique.

FIG.1

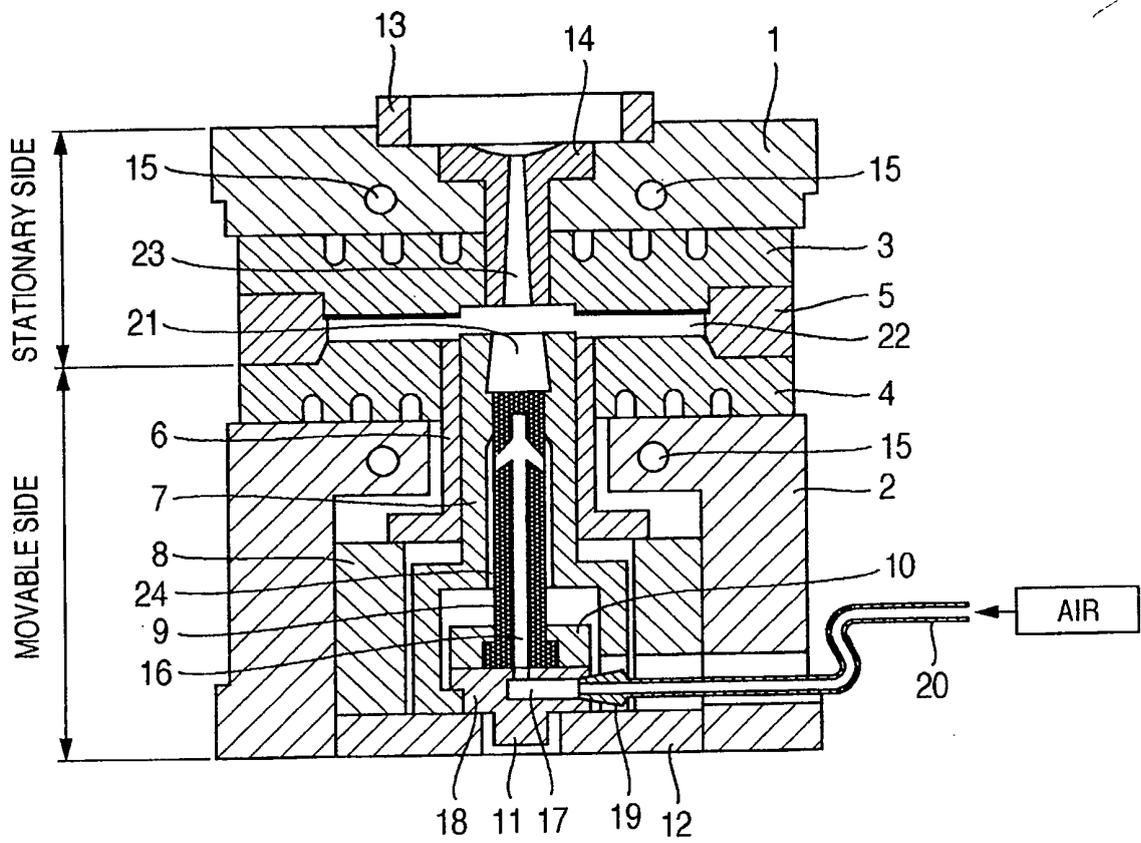


FIG.2

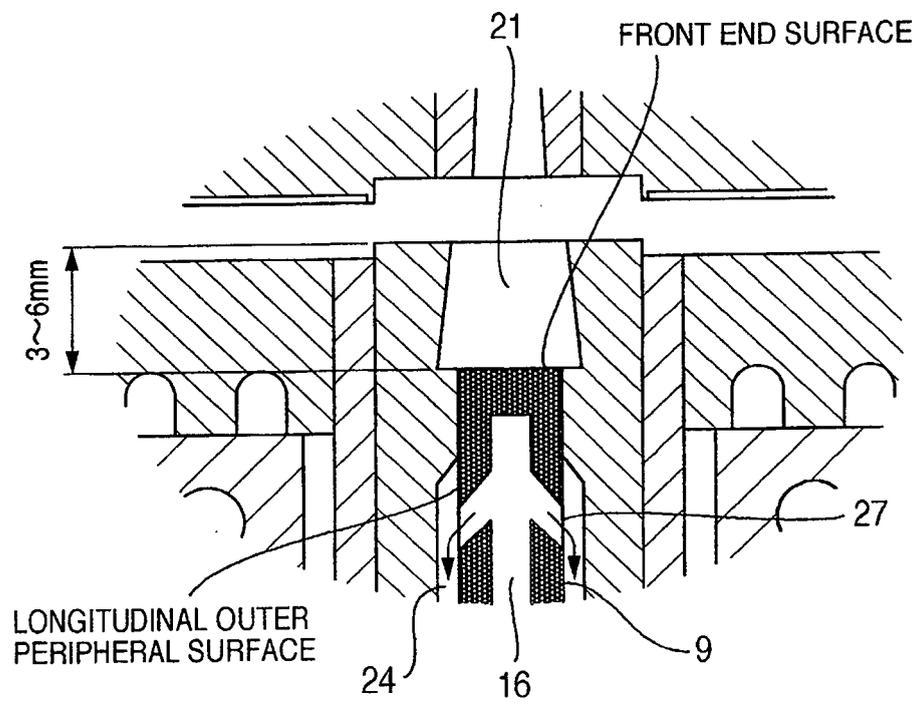


FIG.3

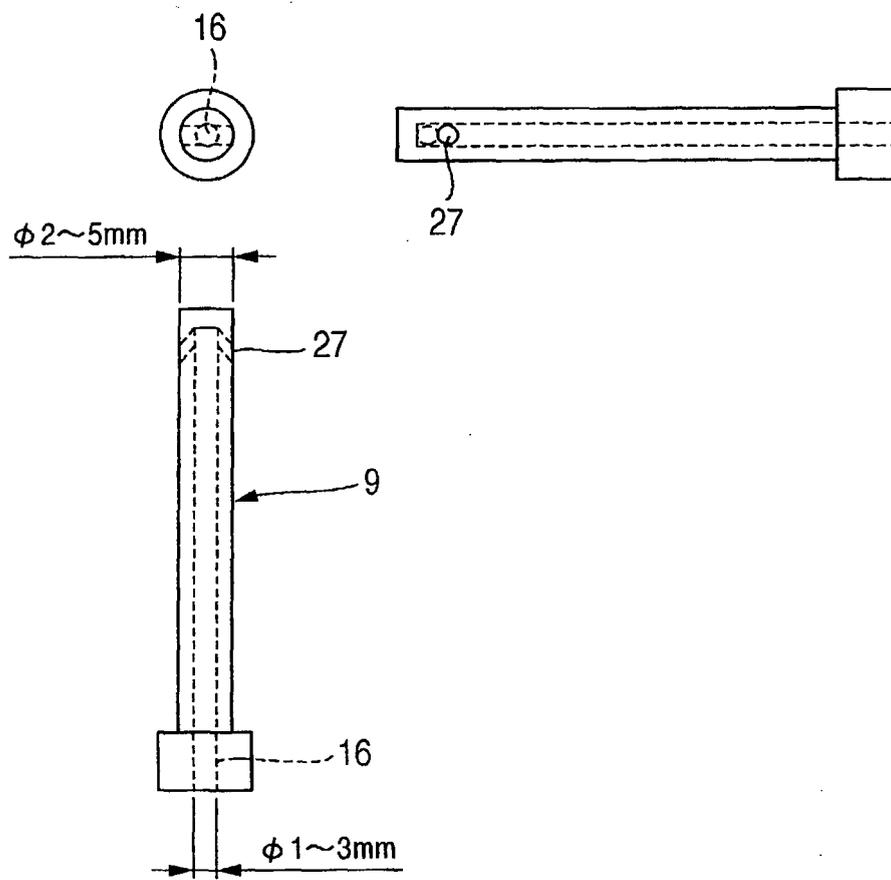
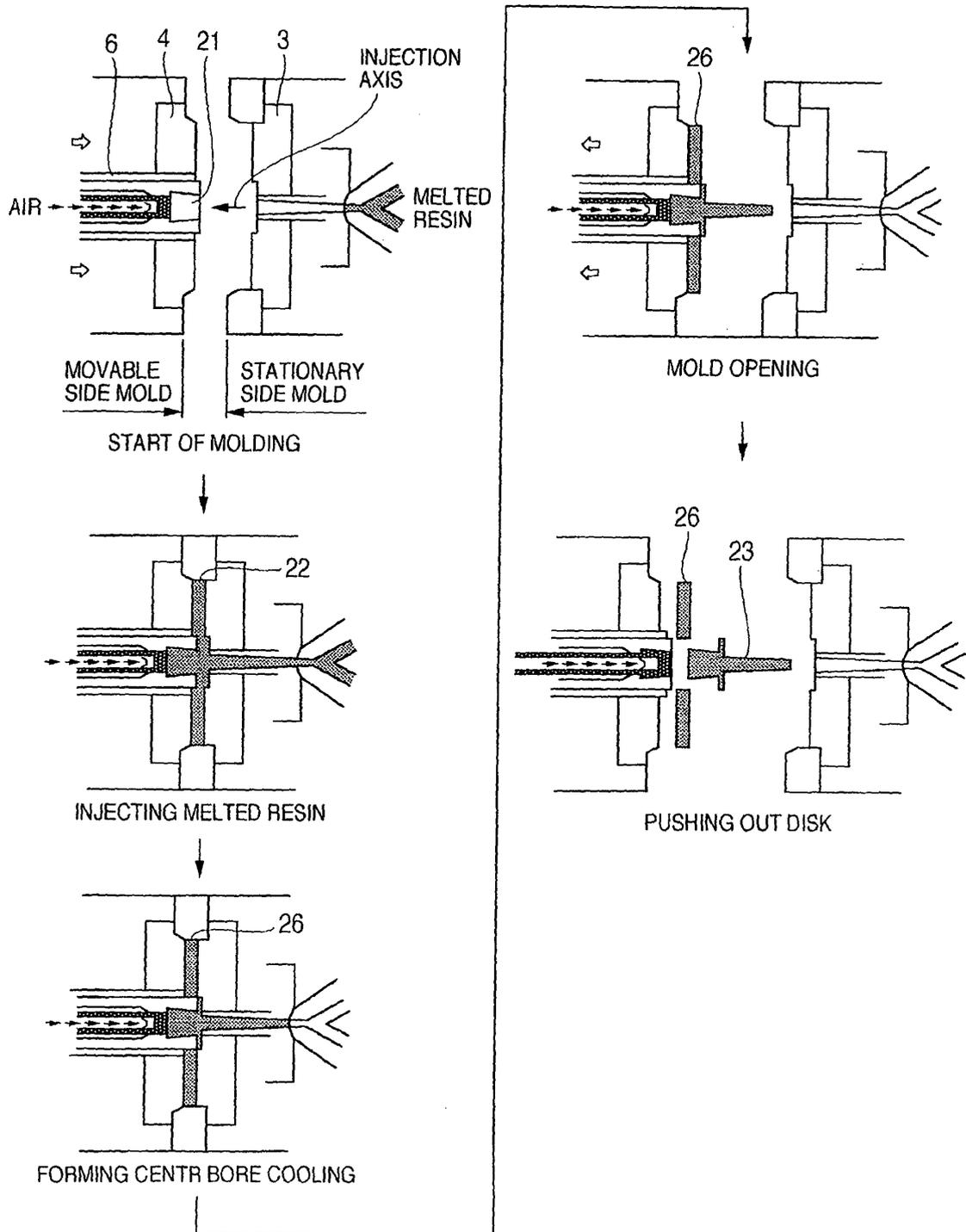


FIG.4



REFERENCES CITED IN THE DESCRIPTION

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